



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

137519
D2214
Job Sheet 168735



Part No: D2214

Job Qty: 2 ea

Part Name: Window, Inside



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/21/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Rotorcraft Support Inc (CROTO01)

16425 Hart Street Van Nuys, CA, 91406 USA ph:(818) 997-7667 fx:(818) 997-1513.

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		11/23/17	0.00	0.00	Start Up Container		SC
100	Waterjet	2 pcs		11/23/17	0.00	0.33	Waterjet1		SC
110	QC	2 pcs		11/23/17	0.00	0.00	QC2		SC
120	QC	2 pcs		11/23/17	0.00	0.00	QC8		
130	Small Fab	2 pcs		11/23/17	0.00	1.00	Small Fab		
140	QC	2 pcs		11/23/17	0.00	0.00	QC5		
150	Small Fab	2 pcs		11/24/17	0.00	0.33	Small Fab		
160	Packaging	2 pcs		11/24/17	0.00	0.00	Packaging3		
170	QC21-SA	2 Ea		11/24/17	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D2214 Dwg Rev: C Prog Rev: C 2-Debur if necessary

Descriptions: 130 - 1-Cut D2462 Seal to length and Install around edge 2-Transfer holes through seal 3-Attach small DART logo labels
D2728-1as per template DT 8223
150 - Wrap window in celophane wrap

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MACRLICS.125	2	2,392	0	0
130-Small Fab	D2462	7	279	0	0
	D2728-1	2	0	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part _____ NCR _____ Date: _____ S013179 Window, Inside PART NO: D2214 Revision: Operation: Change No:	DISPOSITION Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="4">AGAINST DEPARTMENT/PROCESS</th> </tr> <tr> <td style="width: 25%;"> Boss tube ☐ Wall Fab ☐ Finishing ☐ Composite ☐ </td> <td style="width: 25%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width: 25%;"> Engineering ☐ Quality ☐ Other ☐ </td> <td style="width: 25%;"></td> </tr> <tr> <td colspan="3"> Position _____ </td> <td> MRB (QSI042) Approval </td> </tr> <tr> <td colspan="3"></td> <td> Completed By _____ </td> </tr> <tr> <td colspan="3"></td> <td> Lead hand / Supervisor Approval Verification </td> </tr> <tr> <td colspan="3"></td> <td> QC / QA Coordinator Approval </td> </tr> </table>	AGAINST DEPARTMENT/PROCESS				Boss tube ☐ Wall Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐		Position _____			MRB (QSI042) Approval				Completed By _____				Lead hand / Supervisor Approval Verification				QC / QA Coordinator Approval
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FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____	

DART AEROSPACE LTD		Work Order:	168735
Description: Window		Part Number:	D2214
Inspection Dwg: D2214 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.156	+0.005/-0.001	0.156	☒		VK-Ø	
8.50	+/-0.030	8.51	☒		Table	
13.50	+/-0.030	13.51	☒			
6.125	+/-0.010	6.131	☒	Vernier		
6.938	+/-0.010	6.938	☒	Vernier		
X 0.313	+/-0.010	0.308	☒	Vernier		
0.625	+/-0.010	0.625	☒	Vernier		
R0.250	+/-0.010	0.250	☒	Gabor		
0.125	+/-0.010	0.125	☒			

Measured by:	JE 12/06	Audited by:		Prototype Approval:	N/A
Date:	17/11/23	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.20	New Issue	KJ/JLM	
B	08.04.11	Dimensions updated	KJ/DD	